



BaerFix[®]

Thread Repair Kits





BaerFix® Thread Repair Kits for Spark Plug



- Drill Bit HSS
- Drill Bit with reduced shank (13 mm) HSS
- Inserting Tool with hexagonal drive
- BaerFix® Thread Insert with cutting holes, 2 different lengths
- Material: Case-hardened steel, zinc-plated
- Instruction for use

					No.	€
M 10 x 1,0	ZEBW10	12,40	8 mm 2	13 mm 2	F1010	57,06
M 12 x 1,25	ZEBW12	14,50	10 mm 2	14 mm 2	F12125	57,06
M 14 x 1,25	ZBEBW14	17,00	9 mm 2	15 mm 2	F14125	57,06



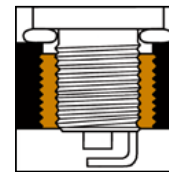
1
Drilling



2
Screwing a
BaerFix® Insert
on the inserting
tool



3
Installing
the insert

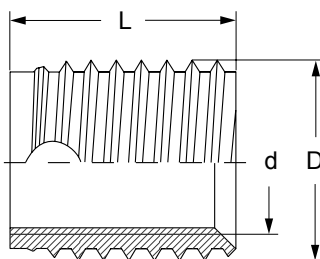



3
Unlocking the
counternut and
screwing off the
inserting tool

BaerFix® Thread Inserts with cutting holes for spark plug

Material

Case-hardened steel, zinc-plated



d	D	L		No.	packin unit	€ pro VPE
M 10 x 1,0	special size	8 mm	12,4 mm	FE101008	5	16,31
M 10 x 1,0	special size	13 mm	12,4 mm	FE101013	5	16,31
M 12 x 1,25	special size	10 mm	14,5 mm	FE121210	5	16,31
M 12 x 1,25	special size	14 mm	14,5 mm	FE121214	5	16,31
M 14 x 1,25	M 17,7 x 1,25	9 mm	17,0 mm	FE141259	5	25,48
M 14 x 1,25	M 17,7 x 1,25	15 mm	17,0 mm	FE141251	5	31,94

Instruction for use

1

Drilling

Clear the damaged thread with a drill bit or create a new hole in the parent material. For strong, hard and tough materials it is recommended to tap the thread (max. intermediate tap) before the installation of BaerFix® Inserts.



2

Screwing BaerFix® Insert on the inserting tool

Screw the BaerFix® Insert, with cutting slots or holes pointing downwards, on the inserting tool. Lock the BaerFix® Insert with the nut by wrench.



3

Installing the insert

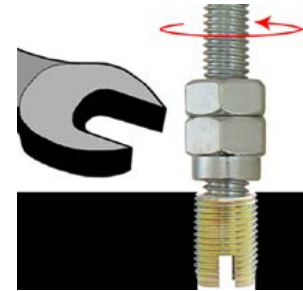
Screw the BaerFix® Insert into the borehole. The BaerFix® Thread Insert is self-tapping. The inserting tool has a 1/4" hexagonal shank and can be used by a cordless screwdriver or a wrench socket.



4

Screwing off the inserting tool

Unlock the counternut by a wrench and screw off the inserting tool. Created bolted connections with BaerFix® Inserts are vibration resistant, wear-free and have a high load capacity in materials with low shearing strength.



Installation by machine

1

Drilling

Clear the damaged thread with a drill bit or create a new hole in the parent material. For strong, hard and tough materials it is recommended to tap the thread (max. intermediate tap) before the installation of BaerFix® Inserts.



2

Configure the machine

Position the workpiece to ensure that hole and machine spindle are in alignment. Set the dimensions, speed values and driving depth (about 0,1 mm till 0,2 mm under the workpiece surface). Turn the external shell, so the stop pin can hold and drive the shell while rotating in clockwise direction. Screw the BaerFix® Insert, with cutting slots or holes pointing downwards, 2 till 4 windings on the inserting tool.



3

Installing the insert

Actuate the machine for screwing the insert into the hole, until the chosen driving depth is reached. Avoid a hard touchdown of the inserting tool on the workpiece to prevent damages on the inserting tool, thread insert or workpiece.



4

Screwing off the inserting tool

Set the machine on reverse running. The stop pin holds the shell while rotating in counterclockwise direction and screws out the inserting tool.



i Please see values for speed and installation torque on page 23.



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